

Work Order ID 159873

Wednesday, April 19, 2017 12:16:41 PM

159873

Page 1

Item ID: D3564-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center
Start Date: 4/23/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 5/2/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 9-89 Date: APR 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	E

100

0.01

100

FLOW WATER JET

Waterjet

Memo

2.72

FLOW CNC Waterjet

1-Cut as per Dwg D3564

Dwg Rev: EProg Rev: E

2-Deburr if necessary

(20)

04/17/23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.20

Quality Control

(20)

04/17/23

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Item ID: D3564-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Center

Start Date: 4/23/2017 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/2/2017 Req'd Qty: 20.00

20

Customer:

Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150						20			DAS 41 9-89
SprayPaint	Memo	0.00							
Spray Painting	APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG) 137327								APR 28 2017
160	QC5- Inspect part completeness to step on W/O	0.00							
160						20			DAS 38 9-89
QC	Memo	0.20							
Quality Control									MAY 01 2017
170	Identify as per dwg & Stock Location: 1P-002	0.00							
170						20			
Packaging	Memo	0.20							
Packaging	LOCATION : FP 002								

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Item ID: D3564-5 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Wearplate Center
Start Date: 4/23/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 5/2/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	2.00							
Quality Control									

DAS
21
9-89

MAY 02 2017

Picklist Print

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Page 1

Work Order ID: 159873

159873

Parent Item: D3564-5

D3564-5

Parent Item Name: Wearplate Center

Start Date: 4/23/2017

Required Date: 5/2/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	106.3320	1.5	31.57895			

M304S16GA

304/316 Sheet .063

m 17/04/24

Location

Loc Qty

Loc Code

MAT010

106.332

m136896

0.3

m137110

0.532

m137175

1.1

m137263

104.4

23

DART AEROSPACE LTD		Work Order: 159873
Description: Wearshoe		Part Number: D3564-5
Inspection Dwg: D3564	Rev: DE <i>DE</i>	Page 1 of 1

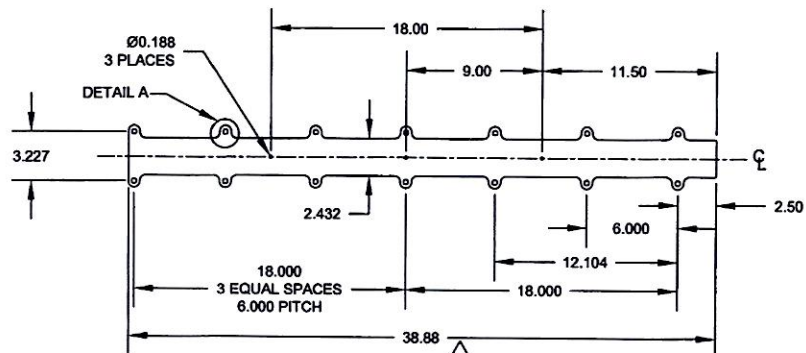
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

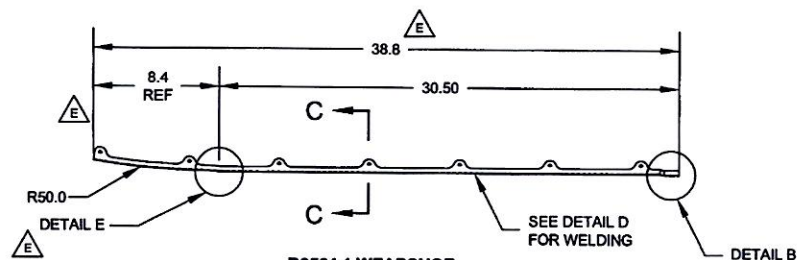
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	1		V=0.02	
6.75	+/-0.030	6.75	1		Tap	
10.00	+/-0.030	10.00	1			
20.00	+/-0.030	20.00	1			
30.00	+/-0.030	30.00	1			
2.50	+/-0.030	2.50	1			
3.227	+/-0.010	3.225	1			
38.500	+/-0.010	38.500	1			
5.500	+/-0.010	5.497	1			
2.50	+/-0.030	2.50	1			
2.432	+/-0.010	2.440	1			
0.300 x 0.300	+/-0.010	0.30 x 0.30	1			
Ø0.188	+0.005/-0.001	Ø.190	1			
R0.375	+/-0.010	0.375	1			
0.063	+/-0.010	0.057	1			

Measured by: <i>DE</i>	Audited by: DAS 38 9-88	Prototype Approval: N/A
Date: 17/04/23	Date: APR 24 2017	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD <i>[Signature]</i>	<i>[Signature]</i>



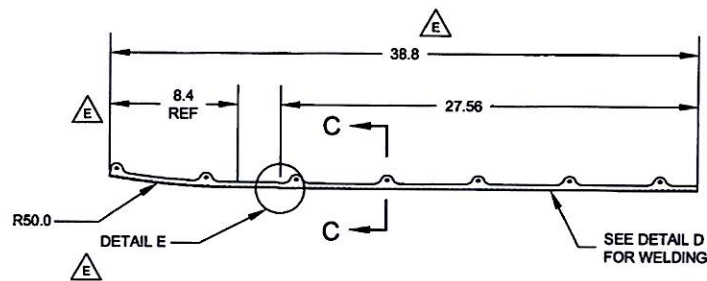
D3564-1F WEARSHOE
(FLAT PATTERN)



D3564-1 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C
- 11) BUILDUP HARD SURFACING 0.08 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 12) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9



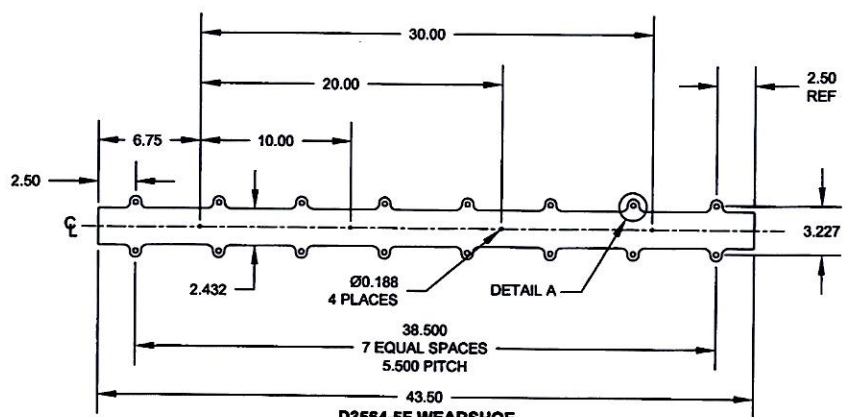
D3564-3 WERESHOE
BENDING DETAIL
(MAKE FROM D3564-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 159873 MJS
170419

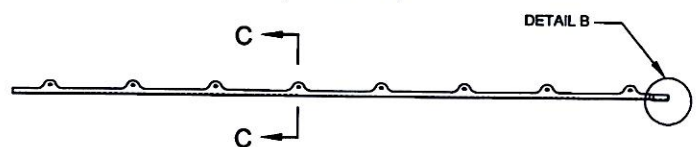
RELEASED
2017-04-12
EN 17-533

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

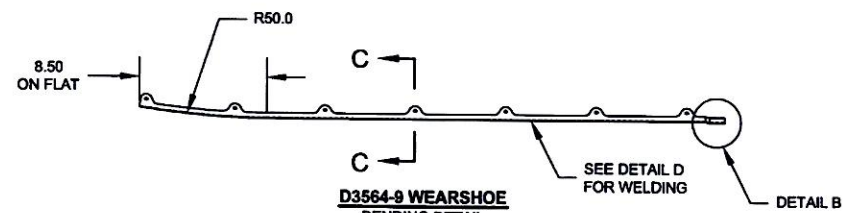
E	UPDATED DRAWINGS TO CURRENT STANDARDS, SHEET 1: UPDATE MATERIAL (NOTE 1), ADD NOTES 11 & 12, FINISH REMOVED, UPDATE DIMS -1,-3. REASON ROBOTIC WELD. SHEET 3: ADD DETAIL E, 3.080 DIM WAS 3.227 AND 2.285 DIM WAS 2.432. REASON: DESIGN ERROR.	SAD	17.01.04
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	08.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	ADS	DRAWING NO.	REV. E
MFG. APPR.	M	D3564	SHEET 1 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	WEARSHOE	NTS
DATE	17.01.04	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



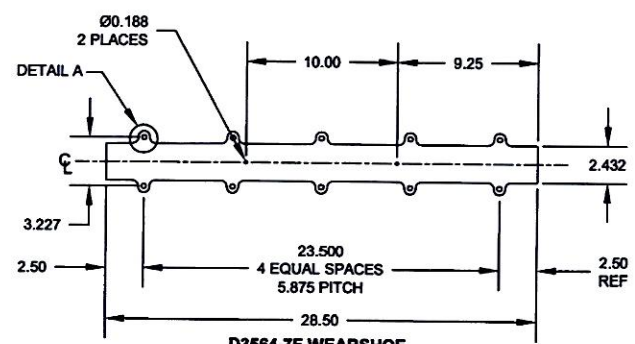
D3564-5F WEARSHOE
(FLAT PATTERN)



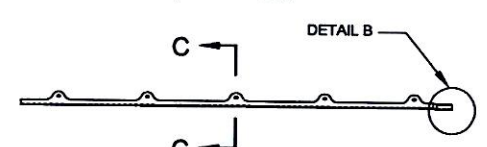
D3564-5 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-5F)



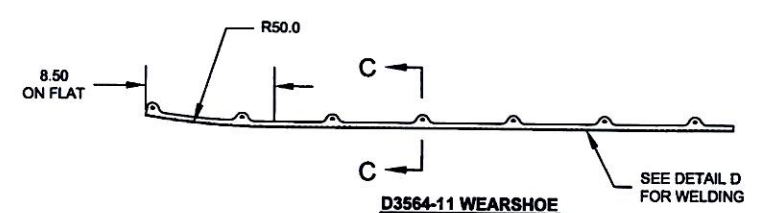
D3564-9 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F WEARSHOE
(FLAT PATTERN)



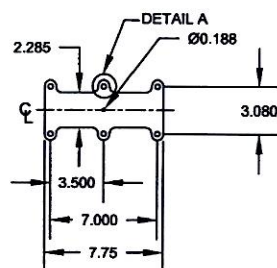
D3564-7 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-7F)



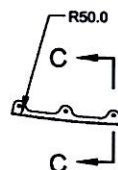
D3564-11 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-1F)

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2017-04-12

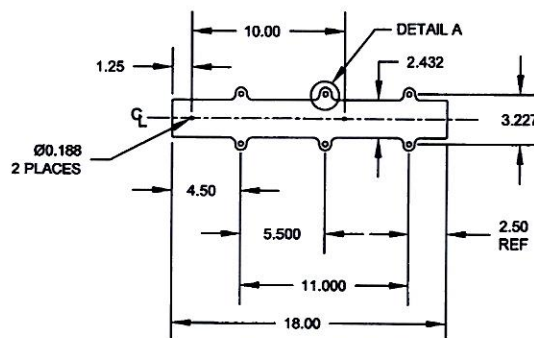
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3564	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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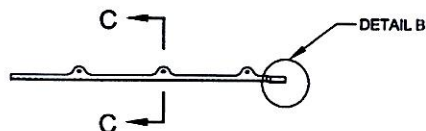
D3564-13F WEARSHOE
(FLAT PATTERN) E



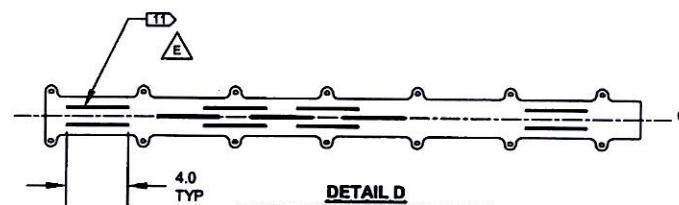
D3564-13 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-13F)



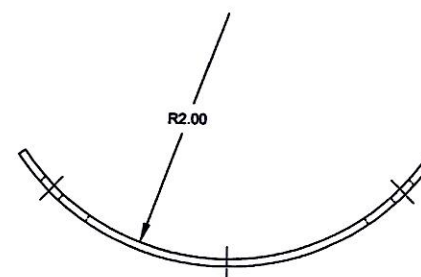
D3564-15F WEARSHOE
(FLAT PATTERN)



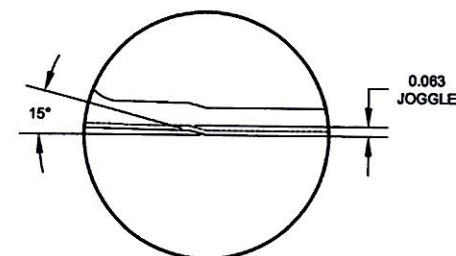
D3564-15 WEARSHOE
BENDING DETAIL
(MAKE FROM D3564-15F)



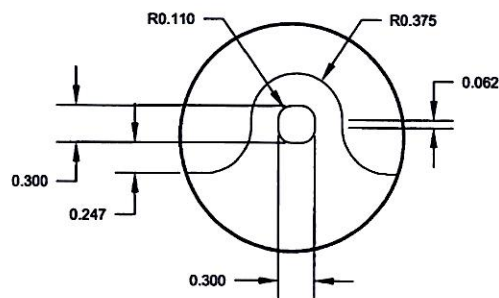
DETAIL D
(D3564-15-31-9/11 WELDING DETAIL)



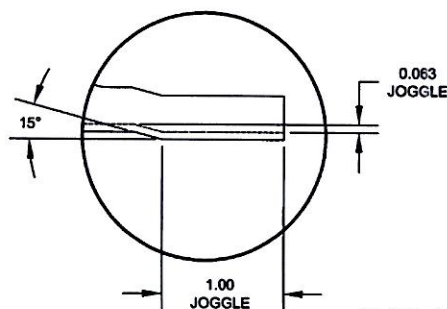
SECTION C-C
SCALE 1X



DETAIL E
SCALE 5X E



DETAIL A
SCALE 8X



DETAIL B
SCALE 8X

RELEASED
2017-04-12

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3564	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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